

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027693**Date Inspected:** 30-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower 123 & 131 Meter El. (Observation of welding , QC inspection and testing of the padeye to tower skin plate) and Tower Corner Stiffeners, 13 Meter El. (Observation of welding and QC inspection).

Will Clifford-Tower Base (Observation of welding and QC inspection of the corner stiffeners), ESW @ Shear Plate "E" (Observation of excavation, welding, QC inspection and testing) and QA/UT verification of OBG E13 drop-in panel splices.

Matt Daggett-OBG W13 Drop-In Plates (Observation of welding, back gouging, QC inspection and testing) and OBG W12 (Observation of excavation, repair welding, QC inspection and testing of deck access hole).

Doug Frey-OBG E13 (Observation of repair welding and QC inspection of drop-in panel field splices), OBG E13 Structural Steel Floor Beams (Observation of welding and QC inspection). Pre-Heat Issue, See QALI Summary.

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

WELDING INSPECTION REPORT

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Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and one (1) issue was noted.

Issue:

This QALI was informed by QAI Doug Frey that during the repair welding of the drop-in panel splice identified as 13E-14E-A2.1, it was noted that the welding was performed without preheat. This QALI instructed Mr. Frey to generate a incident report in regards to this issue and then forward to QA Supervisor William Levell for review and disposition. The Y coordinate was documented as 815 mm.

This QALI continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates). Also, this QALI performed survey and prepared update documentation of the East and West OBG.

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
